



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB877206-5-1
Job Sheet 195959



Part No: RB877206-5-1

Job Qty: 12 pcs

Part Name: Shaft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/3/19

Job Tracking No:

Due Date: 7/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB877206-5 REV 4A IPP REV A 18.02.22 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	SL-154 - 1	12 pcs	7/29/19	7/29/19	0.00	6.00	SL-154 - 1	JB 19-07-04
120	QC 2	12 pcs	7/29/19	7/29/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	JB 19-07-04
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 (613) 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S196010

Part: RB877206-5-1

Job No: 195959

Serial No/Batch: S196010

Revision: 4A

Inspector:

Exp Date:

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130 QC 8	12 pcs	7/29/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	m 19/07/06
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
132 Outsource - 12 - Black Oxide	12 pcs	7/29/19	0.00 0.00	GRO002	2019-07-10
134 Packaging 2-1 - Receive - B4B	12 pcs	7/29/19	0.00 0.00	Packaging 2 - 1 - B4B	JUL 22 2019
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	

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				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
136	QC 6	12 pcs	7/29/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
140	Packaging 3-1 - Stock - B4B	12 pcs	7/29/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
150	QC 21 - SA	12 pcs	7/29/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

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JUL 2 3 2019

GAYLIE

Part Op 110 - SL-154 (MORI SL-154 LATHE) 1-Machine as per DWG. FB954 FOLIO REV: AA DWG REV: 4A
 Descriptions: 2-Debur

120 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB)

130 - QC8 Machining-4 (QC8- Inspect parts - second check)

132 - Outsource12 (Outside Processing - Black Oxide) 1- Issue P/O to Groupe Altech; PO 43957 2- Black oxide finish, MIL-C-13924C Class 1 3- Certificate of Conformity is required

134 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)

136 - QC6 (QC6- All purchased or subcontracted products)

140 - Packaging3-1 (Identify as per dwg & Stock Location: _____)

150 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R0.750	AISI 1144 Stressproof Round Bar 0.750"	3.9960 ft (.333 ea)	110-SL-154 - 1	S186693

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-1144-R0.750	4	22	0

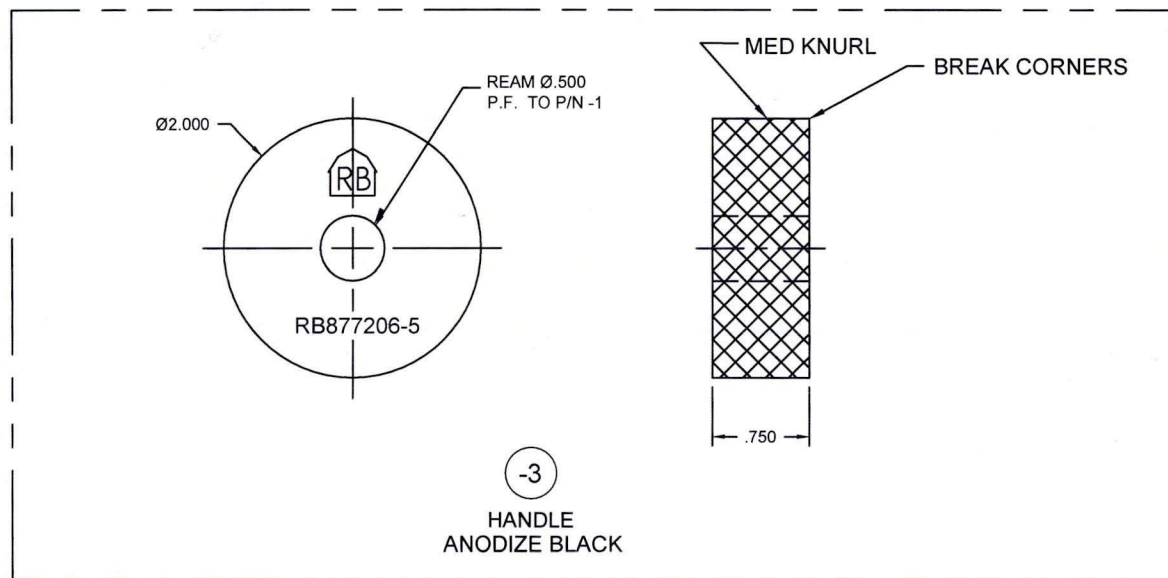
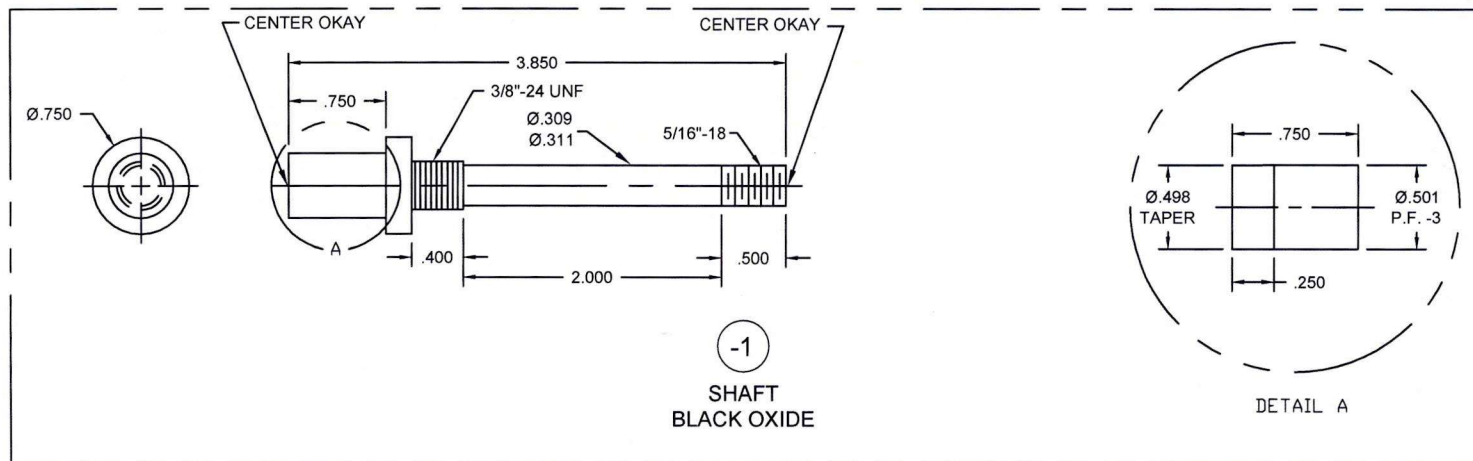
Part Specifications

Specifications could not be found.

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This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
4A	CH'D TITLEBLOCK & REVISION BLOCK, CORRECTED VIEWS & LABELED ALL SECTION VIEWS, ADDED DETAIL A P/N -1 TO CLARIFY TAPER.	9/29/09	RJC	RW



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195959 MLO
19-06-03

RED BARN MACHINE	
TITLE BEARING CUTTER	
DWG NO. RB877206-5-1 & -3	REV 4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-28-01
SHEET 2 of 4	

RB877206-5-1

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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



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PURCHASE ORDER

POHB043957



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043957

PO Date: 7/9/19

Due Date: 7/17/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-07-19

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	R197342	RBE350A94-3700-C-01	Tube -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; A513 -Certificate of Conformity is required	Firmed	-	7/17/19	7 pcs	0 pcs	7 pcs	\$0.01/pcs	\$0.07
2	195959	RB877206-5-1	Shaft Outsource12 (Outside Processing - Black Oxide) 1- Issue P/O to Groupe Altech; PO 2- Black oxide finish, MIL-C-13924C Class 1 3- Certificate of Conformity is required	Firmed	-	7/17/19	8 pcs	0 pcs	8 pcs	\$2.25/pcs	\$18.00

7x JUL 22 2019

8x JUL 22 2019

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PURCHASE ORDER

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Items												
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
3	195944	RBD29905-11	Short Center Pin (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/17/19	8 pcs	0 pcs	8 pcs	\$1.75/pcs	\$14.00	
							8 X JUL 22 2019					
4	195945	RBD29905-13	Long Center Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/17/19	8 pcs	0 pcs	8 pcs	\$1.90/pcs	\$15.20	
							8 X JUL 22 2019					
5	196129	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/17/19	32 pcs	0 pcs	32 pcs	\$2.50/pcs	\$80.00	
							32 X JUL 22 2019					
6	196184	RBIR7028-1	Receiver (Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	7/17/19	9 pcs	0 pcs	9 pcs	\$3.40/pcs	\$30.60	
							9 X JUL 22 2019					



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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	196185	RBIR7028-3	Remover / Installer (Outside Processing - Black Oxide)-Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL- C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF- 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/17/19	9 pcs	0 pcs	9 pcs	\$2.35/pcs	\$21.15
8	196186	RBIR7028-5	Alignment Seat (Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL- C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF- 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/17/19	9 pcs	0 pcs	9 pcs	\$2.80/pcs	\$25.20
Grand Total:										\$204.22	

[Handwritten signatures]



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PURCHASE ORDER

POHB043957



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/19/19 11:00 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020660-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

020660 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
19-Jul-2019		Jigar Patel		POHB043957				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NG Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-3700-C-01 REWORK Rev.	RBE350A94-3700-C-01 REWORK SAND BLAST ALL OVER BLACK OXIDE MIL-C-13924C, CLASS 1 APPLY THIN LAYER OF OIL /CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	BLACK-OXIDE N/C	7	7	0	0	0
2	RB877206-5-1 Rev.	RB877206-5-1 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8	0	0	0
3	RBD29905-11 Rev.	RBD29905-11 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] SPÉC: MIL-C-13924C, CLASS 1 ***	BLACK-OXIDE CH	8	8	0	0	0
4	RBD29905-13 Rev.	RBD29905-13 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] SPÉC: MIL-C-13924C, CLASS 1 ***	BLACK-OXIDE CH	8	8	0	0	0
5	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	32	32	0	0	0
6	RBIR7028-1 Rev.	RBIR7028-1 SAND BLAST ALL OVER OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL /CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	9	9	0	0	0
7	RBIR7028-3 Rev.	RBIR7028-3 SAND BLAST ALL OVER OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL /CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	9	9	0	0	0

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Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
19-Jul-2019		Jigar Patel		POHB043957					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
8	RBIR7028-5 Rev.	RBIR7028-5 SAND BLAST ALL OVER OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE3 OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	9	9	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.